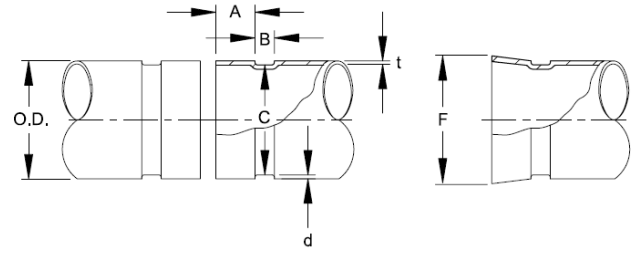


## STANDARD ROLL GROOVE FOR LARGE DIAMETER IPS PIPE



1 Nominal Size	2 Pipe Outside Diameter			3 A $\pm 0.03$ $\pm 0.8$	4 B $\pm 0.03$ $\pm 0.8$	5 C $+0, -0.063$ $+0, -1.6$	6 d Groove Depth (ref)	7 t Min. Allow Wall thick	8 Max. Allowed Flare Dia.
	Basic	Tolerance							
	in	in	in	in	in	in	in	in	in
	mm	mm	mm	mm	mm	mm	mm	mm	mm
26	26.0	+0.093	-0.031	1.75	0.625	25.5	0.25	0.25	26.2
650	660.4	+2.36	-0.79	44.5	15.9	647.7	6.4	6.4	665.5
28	28.0	+0.093	-0.031	1.75	0.625	27.5	0.25	0.25	28.2
700	711.2	+2.36	-0.79	44.5	15.9	698.5	6.4	6.4	716.3
30	30.0	+0.093	-0.031	1.75	0.625	29.5	0.25	0.25	30.2
750	762.0	+2.36	-0.79	44.5	15.9	749.3	6.4	6.4	767.1
32	32.0	+0.093	-0.031	1.75	0.625	31.5	0.25	0.25	32.2
800	812.8	+2.36	-0.79	44.5	15.9	800.1	6.4	6.4	817.9
36	36.0	+0.093	-0.031	1.75	0.625	35.5	0.25	0.25	36.2
900	914.4	+2.36	-0.79	44.5	15.9	901.7	6.4	6.4	919.5
40	40.0	+0.093	-0.031	2.00	0.625	39.5	0.25	0.25	40.4
1000	1016.0	+2.36	-0.79	50.8	15.9	1003.3	6.4	6.4	1026.2
42	42.0	+0.093	-0.031	2.00	0.625	41.5	0.25	0.25	42.2
1050	1066.8	+2.36	-0.79	50.8	15.9	1054.1	6.4	6.4	1071.9

**Nominal Pipe Size (Column 1):**

Nominal pipe size, IPS pipe to ANSI B36.10 and ISO 4200.

**Pipe OD (Column 2):**

Maximum allowable tolerances from square cut are 0.060" (1.6mm).

**Gasket Seating Surface (Column 3):**

The gasket seating surface 'A' shall be free from deep scores, marks, or ridges that would prevent a positive seal.

**Groove Width (Column 4):**

Groove width is to be measured between vertical flanks of the groove side walls.

**Groove Diameter (Column 5):**

The 'C' dimensions are average values. The groove must be of uniform depth around the entire circumference. Use a **Shurjoint** groove or rule to check the groove diameter.

**Groove Depth (Column 6):**

The 'd' is for reference use only. The groove depth shall be determined by the groove diameter 'C'.

**Minimum Wall Thickness (Column 7):**

The 't' is the minimum allowable wall thickness that may be roll-grooved.

**Flare Diameter (Column 8):**

The pipe end that may flare when the groove is rolled shall be within this limit when measured at the extreme end of the pipe.

Note:

- **Shurjoint** reserves the right to change specifications, designs and or standard equipment without notice and without incurring any obligations.